

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-008849**Date Inspected:** 24-Aug-2009**Project Name:** SAS Superstructure**OSM Arrival Time:****Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:****Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Lv Li qing**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, S.Chandrakumar was present during the times noted above for observations relative to the work being performed.

BAY#14

This QA Inspector observed the following work in progress:

FCAW welding of weld joint 1G-003 located on PCMK CA-61 welder is identified as 0201215 & 0207465.ZPMC QC is identified as Mr. Li Ming Yang. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2231-Tc-U4b-F.

FCAW welding of weld joint 2G-004 located on PCMK CA-71 welder is identified as 045240 & 045276.ZPMC QC is identified as Mr. Li Ming Yang. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2232-Tc-U4b-F.

FCAW welding of weld joint 2F-017 located on PCMK CSD2-PP81.5 welder is identified as 0204730.ZPMC QC is identified as Mr. Xuo tao. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2132.

Excess root gap (more than 5mm) of following fillet weld joint Fit-up indentified and informed to ZPMC QC Mr. Xuo tao.

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CSD3-PP94-138/139 of CA77.

CSD2-PP90.5-039/040 of CA73.

Segment 6AW

Ongoing ZPMC UT of Excess root opening in Deck diaphragm fillet converted into CJP weld of PP38-003/004
Witnessed and NDT QC technician identified as Mr. Wang wei ming.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No Relevant Conversation.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Jim Simonis - 134-7246-3441, who represents the Office of Structural Materials for your project.

Inspected By:	Kumar,Chadra	Quality Assurance Inspector
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Reviewed By:	Clifford,William	QA Reviewer
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